

# Work Order ID 58723

Tuesday, May 18, 2010 8:02:55 AM



Page 1

Item ID: D3276-042

Accept



Setup Start



Revision ID:

Item Name: Baffle Assembly RH

Stop



Start Date: 5/17/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 5/17/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*M*

Date:

*7-5-18*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3276

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3276 ☐ Dwg Rev: *B* ☐ Prog Rev: *B* ☐ 2-  
Debur if necessary

*6061 . 040*

*B10-5-18*

*(S)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*B10-5-18*

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*S. Webster*

*(+S)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

SB 10/05/19

⑤

Small Fab

1-Deburr 2-Roll as per Dwg D3276

140

0.00



NC BRAKE

Brake NC

Memo

0.00

SB 10/05/19

⑤

Brake NC

Form as per Dwg D3276

150

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

SB 10/05/20

⑤

Quality Control

W/O:		WORK ORDER CHANGES					
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Item Name: Baffle Assembly RH

Start Date: 5/17/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 5/17/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

5 BR 10-500

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:00pm FINISH TIME: 2:30pm OVEN TEMPERATURE: 220°F

90 10/05/20

5 0

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

5 BR 10-5-20

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Assemble as per Dwg D3276

6/5/05/27 (5)

200



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/05/27

(25)  
-042

210



Packaging

Packaging

Identify as per dwg &amp; Stock Location:

175

0.00

Memo

0.00

10-5-07 (50) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Cust Item ID:

Required Date: 5/17/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/01

MF  
10-5-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 18, 2010 8:03:00 AM

Page 1

Work Order ID: 58723

Parent Item: D3276-042

Parent Item Name: Baffle Assembly RH

Comments: IPP Rev:A New Issue 05-12-06 JLM  
IPP Rev:B Now on Waterjet 06-09-06 JLM

Start Date: 5/17/2010

Required Date: 5/17/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3276-3 Decal		Manufactured	No			110	Each	13.0000	1		5/10/05/27	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST048				13				
				52913				1				
				56593				12				
D2464 3/4 Seal		Manufactured	No			190	f	369.1934	2.25		5/10/05/27	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST402				369.1934			11.250	
				48173				369.1934				
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No			190	sf	103.0000	1.0205		5.7	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				MAT21				103			113004	
				113004				103				

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

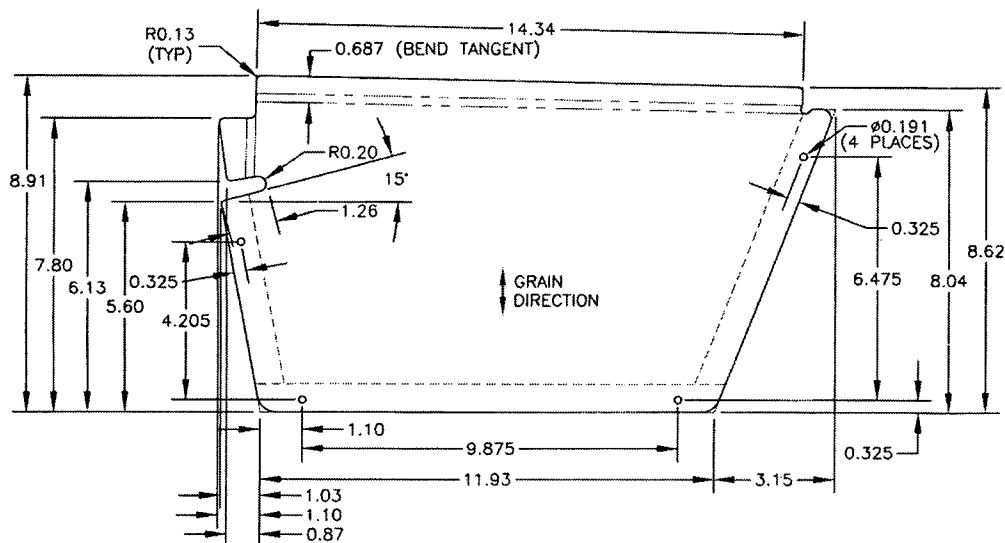
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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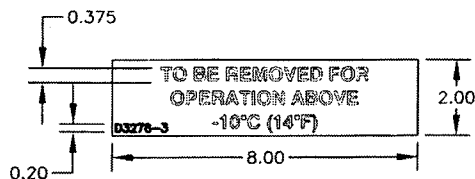
NOTE: Date & initial all entries





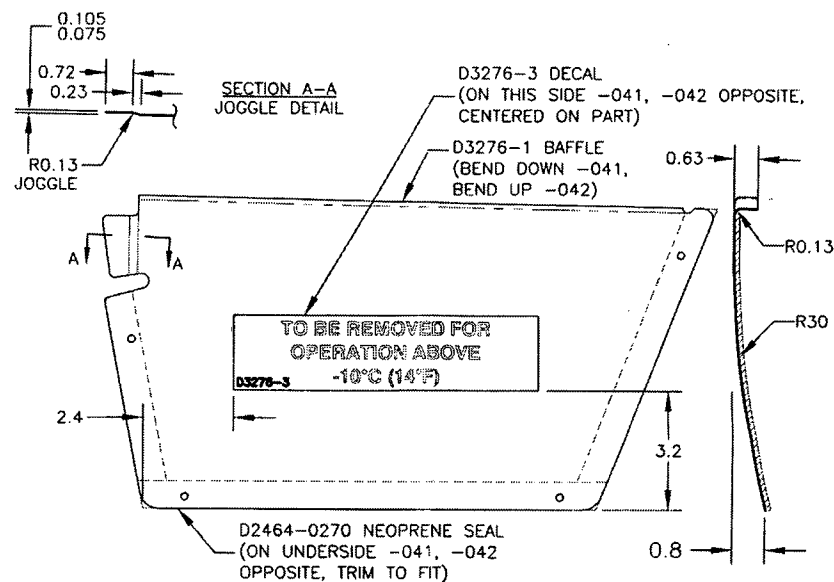
#### D3276-1 BAFFLE (FLAT PATTERN)

- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)  
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



#### D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



#### D3276-041 BAFFLE ASSEMBLY, LH (SHOWN) D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 57223  
BS-0-5-10

RELEASED  
05.01.07

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PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

B	05.01.25	LABEL NOW -10°C; CURVE PART	
A	05.01.07	NEW ISSUE	
DESIGN	CP	DRAWN BY	CP
CHECKED	#	APPROVED	#
DATE	05.01.25	DRAWING NO.	D3276
		TITLE	BAFFLE ASSEMBLY
		REV. B	SHEET 1 OF 1
		SCALE	1:1

**DART** DART AEROSPACE LTD.  
HARRISBURG, ONTARIO, CANADA

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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